

Date: Thursday, 2/1/2007 9:04:23 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	204 ASPIRATOR ASSEMBLY
Job Number	30567 -		Part Number	D2306
Estimate Number	11834		Drawing Number	D2306 REV C
P.O. Number	N/A		Project Number	N/A
This Issue	2/1/2007	S.O. No. : N/A	Drawing Revision	C
Prsht Rev.	NC		Material	N/A
First Issue	1/31/2007	Type : SMALL /MED FAB	Due Date	3/15/2007
Previous Run	N/A		Qty:	4
Written By	JL		Um:	Each
Checked & Approved By	JL 07.02.01			
Comment	Est. A 98.09.10 New KS			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D22891	Mounting Brkt, LH		
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Mounting Brkt, LH Qty Part Number Description Batch No. 1 D2289-1 Valve Mounting Brkt B3847		
2.0	D22892	Mounting Brkt, RH		
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Mounting Brkt, RH Qty Part Number Description Batch No. 1 D2289-2 Valve Mounting Brkt B3847		
3.0	D2295	Heater Outer Skin		
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Heater Outer Skin Qty Part Number Description Batch No. 1 D2295 Exterior Sheet B3840 x1		
4.0	D2294	Perforated sheet		
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Perforated sheet Qty Part Number Description Batch No. 1 D2294 Perforated Sheet B30578		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: 204 ASPIRATOR ASSEMBLY
Job Number: 30567			Part Number: D2306
Job Number: 			
Seq. #:	Machine Or Operation:		Description :
5.0	D2301		Insulation Filter 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Insulation Filter			 <i>B70987 B 30572-1</i>
6.0	D2302		Intake Weldment 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Intake Weldment			 <i>B30581</i>
7.0	D2303		Outlet Weldment 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Outlet Weldment			 <i>B30582</i>
8.0	D2317		Valve Mtg Bracket 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Valve Mtg Bracket			 <i>B4744</i>
9.0	D2334		Control Cable Mounting B 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Control Cable Mounting B			 <i>B3841A</i>
10.0	D2342		Heater Bracket 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Heater Bracket			 <i>B30583</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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355 x2 275 x4

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 204 ASPIRATOR ASSEMBLY	
Job Number: 30567		Part Number: D2306	
Job Number: 			
Seq. #:	Machine Or Operation:		Description :
11.0	D2375416163		Insulation 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Insulation			
Qty	Part Number	Description	Batch No.
1	D2375-4-16-163	Insulation	<u>M1810</u>
12.0	AN33A		Bolt 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Bolt			
Qty	Part Number	Description	Batch No.
4	AN3-3A	Bolt	<u>M102380</u>
13.0	AN960JD10		Washer 
Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s) Washer			
Qty	Part Number	Description	Batch No.
8	AN960JD10	Washer	<u>M100274</u>
14.0	MS20600AD4W5		Blind Rivet 
Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s) Blind Rivet			
Qty	Part Number	Description	Batch No.
7	MS20600AD4W5 (or CR9163-4-5)	Rivet	<u>M7209</u>
15.0	MS20600AD4W6		Rivet 
Comment: Qty.: 23.0000 Each(s)/Unit Total : 92.0000 Each(s) Rivet			
Qty	Part Number	Description	Batch No.
23	MS20600AD4W6 (or CR9163-4-6)	Rivet	<u>M0325x36</u> <u>M103481x56</u>
16.0	MS20470AD46		Rivet, Universal Head 
Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s) Rivet, Universal Head			
Qty	Part Number	Description	Batch No.
26	MS20470AD46 (or CR9163-4-6)	Rivet	<u>M18615</u>

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		MS 20600 AD4W3 MS 20600 AD4W4	M 4747	07-03-27	12	18 07-03-27	18 07-03-27
		MS 20470 AD4-5		07-03-27	8	18 07-03-27	18 07-03-27

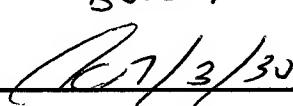
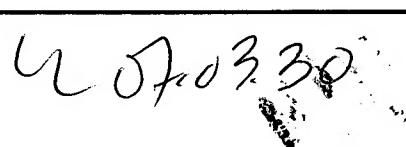
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 30567		Part Number: D2306	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
17.0	MS21042L3 	Nut 	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Nut Qty Part Number Description Batch No. 4 MS21042L3 Nut M102217 (or MS21042-3)			
18.0 	NAS1329A3K80 	Insert 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Insert Qty Part Number Description Batch No. 2 NAS1329A3K80 Insert M 9662 			
19.0 	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg. D2306  PTO			
20.0	QC5 	INSPECT WORK TO CURRENT STEP 	
Comment: INSPECT WORK TO CURRENT STEP 			
21.0 	PACKAGING 1 	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ PPP D204-575-01 B30517 			
22.0	QC21 	FINAL INSPECTION/W/O RELEASE 	
Comment: FINAL INSPECTION/W/O RELEASE 			
Job Completion 			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-03-20	19b	Powder Coat white as per QSI 5 4.3	fel	07/03/20	1	18 Eng 07-03-20	AB 07-03-20
07-03-20	19c	Inspect level 3	AB	07-03-20	1	18 Eng 07-03-20	AB 07-03-20

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NOTE: Date & initial all entries

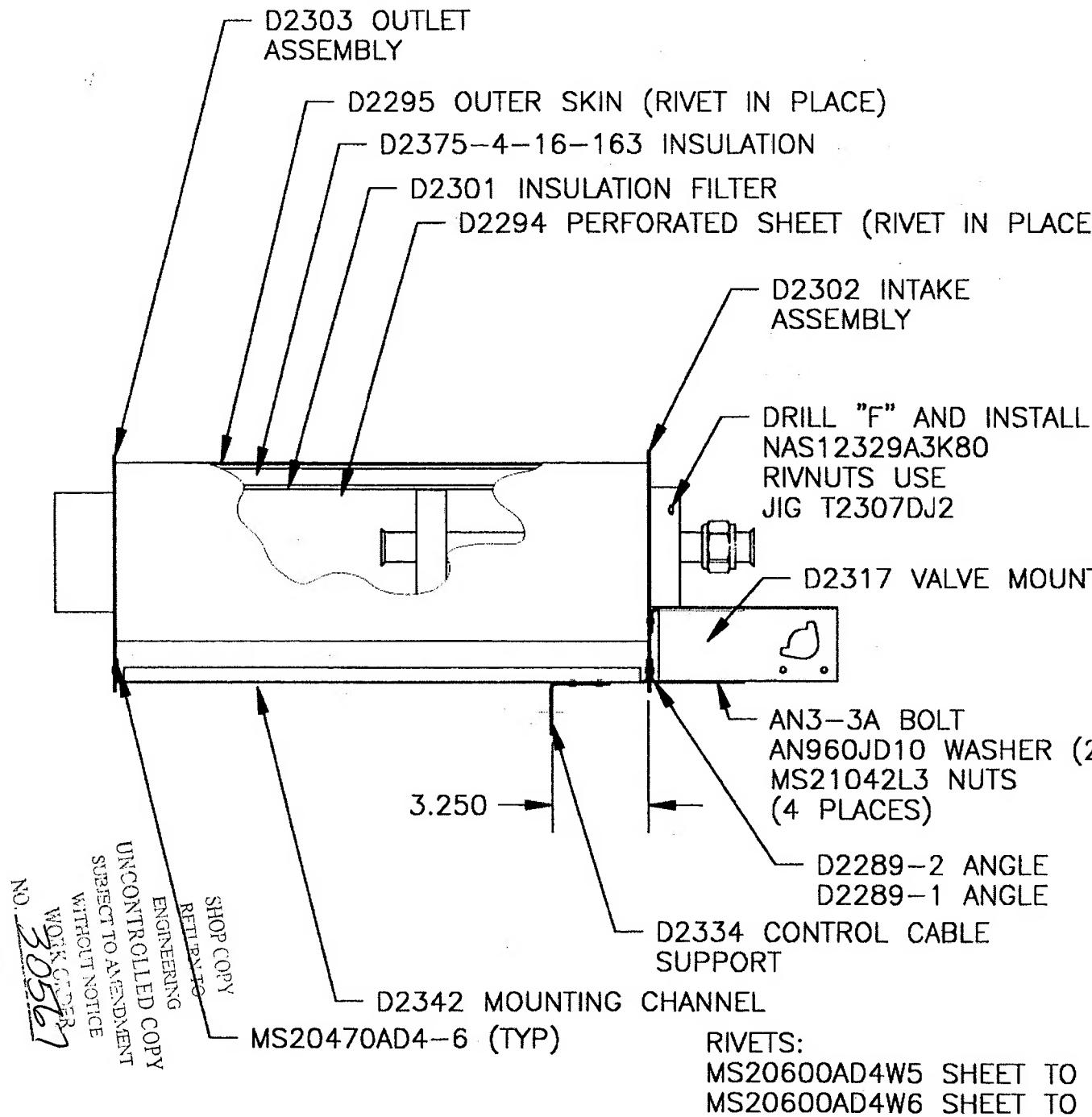
DART

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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B	APPROVED B	DRAWING NO. D2306	REV. C SHEET 1 OF 2
DATE 95.01.03	TITLE B204 ASPIRATOR ASSEMBLY		SCALE
B	REVISED D2317		
C	96.01.19 ADDED DETAIL		

QTY	Part No.	Description
X	D2306	B204 ASPIRATOR ASSEMBLY
1	D2302	INTAKE WELDMENT ASSEMBLY
1	D2303	OUTLET WELDMENT ASSEMBLY
1	D2295	HEATER EXTERIOR SHEET
1	D2375-4-16-163	INSULATION
1	D2301	INSULATION FILTER
1	D2294	HEATER PERFORATED SHEET
1	D2289-1	VALVE MOUNTING BRACKET
1	D2289-2	VALVE MOUNTING BRACKET
1	D2317	VALVE MOUNTING BRACKET
1	D2334	CONTROL CABLE SUPPORT
1	D2342	MOUNTING CHANNEL
4	AN3-3A	BOLT
8	AN960JD10	WASHER
7	MS20600AD4W5	RIVETS CR9163-4-2
23	MS20600AD4W6	RIVETS CR9163-4-4
6	MS20470AD4-6	RIVETS
4	MS21042L3	NUTS
2	NAS1329A3K80	RIVNUTS

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WITHOUT NOTICE
WORK ORDER
NO. *30567*



DART

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COAO

DESIGN	DRAWN BY	DART AEROSPACE LTD
		VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
B. WILLIAMS	B. WILLIAMS	D2306
B. <u>W</u>	B. <u>W</u>	DATE
		95.01.03
		TITLE
		B204 ASPIRATOR ASSEMBLY
		SCALE

